Work Order Monday, June 20, 2											Page 1
Revision ID: Item Name: Sp		Start Qty: 20.00 Req'd Qty: 20.00			Cust Item I Customer:	D:		s	Setup Sta		
	rocess Plan	:	Date: <u>//- (X</u>	Z/Tooling: SPC (Y/N):		ate:		R	Run Sta	1	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ion Nbr						~~	20	- Training	- Cump
Waterjet FLOW CNC Waterjet DELEN		FLOW WATER JET Memo		0.00 0.00 g Rev:□Prog Rev:_	<u>C</u> □2-			_B(1-	6-38	(b)	·
110 QC Quality Control		QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00		:		1311-	6-A		
120 		QC8- Inspect parts - seco	and check	0.00 Wo	Tel 29		(,	alele			

Quality Control

-4.170	. oopaoc E	·								
W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	NGE	B	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Cateç	gory:	_ NCR: Y	es N	o DQ	A:	Date: _	
	Reso	olution:	Disposition):	QA: N/	C Clos	sed:		Date: _	
NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Initial	Action Description		gn &	Verific Secti	cation	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		ate				
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NOTE: Date & initial all entries

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Work Order ID 70984

Monday, June 20, 2011 2:50:31 PM



Page 2

Item ID:

D3278-3

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Spacer

6/20/2011

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Required Date: 6/23/2011

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date: _____

SPC (Y/N):

Date:

Accept

Qty

Reject

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Memo

1-C'sink as per dwg D3278□2-Deburr

Set Up/ **Run Hours**

0.00

0.00

Code

Tool # Plan

Reject Qty

Stop

Insp. Number Stamp

140

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location MA | LAb

0.00

150

Packaging Packaging

Memo

0.00

0.00

Dait Aci	Ospace	Liu							
W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC			on B	Verifi	cation	Approval	Approval
DAIL	J	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 70984

Monday, June 20, 2011 2:50:31 PM



Page 3

Item ID:

D3278-3

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Spacer

6/20/2011

Start Qty: 20.00

Required Date: 6/23/2011 Req'd Qty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

A	nn	rn	va	s:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



QC:

Date: _____

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Reject

Reject

Insp. Stamp

Sequence ID/ Work Center ID

160

QC

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Run Hours

0.00

0.00

Accept Code Qty

Qty

Number

CZ11/07/04

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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	on:	QA: N/C Clo	sed:		Date: _		
NCR:		\	WORK ORE	ER NON-CONFORMA	NCE (NCR)				
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DATE	STEP	section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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Picklist Print

Monday, June 20, 2011 2:50:37 PM

Work Order ID: 70984

Parent Item:

D3278-3

Parent Item Name: Spacer



Start Date: 6/20/2011

Required Date: 6/23/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP . A□ 04.04.19□New issue□KJ/JLM□

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINS0.125		Purchased	No			110	sf	0.0000	0.0344	0.724211			, ·· , · · <u>,</u> ₁ , · ·
						•				BG-3-112			

Black Delrin Sheet .125

45×761.

m 116779



moletrin So. 125424.0

	. Johnson								
W/O:			WC	RK ORDER CHANGI	ES				
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A :	Date: _	
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NCR: WORK ORDER NON-CONFORMANCE (NCR)									
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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	769.84
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.988	4	3	V 1B02	
1.98	+/-0.030		×		V	
1.480	+/-0.005	1.480	4		V	
0.250	+/-0.010	02 G ·	9		V	
1.480	+/-0.005	1.480	ъ		γ	
0.250	+/-0.010	950	>>		V	
Ø0.098	+0.005/-0.000	,101,	>		V	
R0.13	+/-0.030	سُ	>		R.G.	
0.125	+/-0.010	.135	7		٧	
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Measured by:	Audited by:	Prototype Approval: N/A
Date: 11~6~	78 Date: (1/1)	Date: N/A

Rev	Date	Change -	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	06.03.09	Dwg Rev updated	KJ/JLM	
С	07.02.02	Dwg updated per JLM	KJ/JLM	
D	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	B

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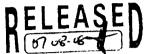
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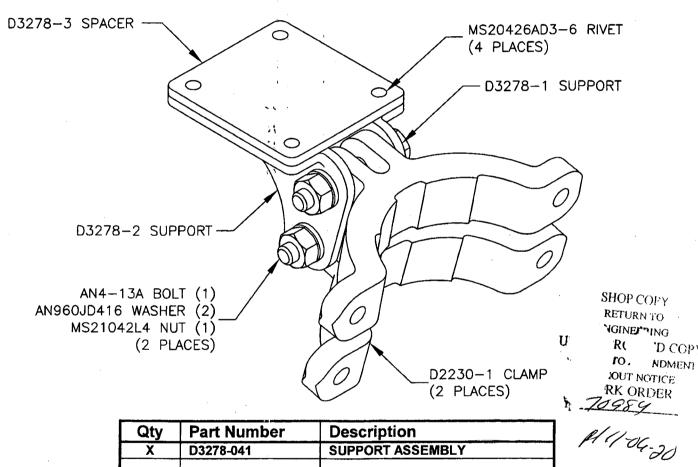


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	-P	#	D3278 SHEET 1 OF	3
DATE			TITLE SCAL	LE
07.0	7.24		SUPPORT ASSEMBLY N	TS
Α		04.03.03	NEW ISSUE	
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

07.07.24 | CHANGED RIVETS PER PAR #185



D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
Х	D3278-041	SUPPORT ASSEMBLY
		,
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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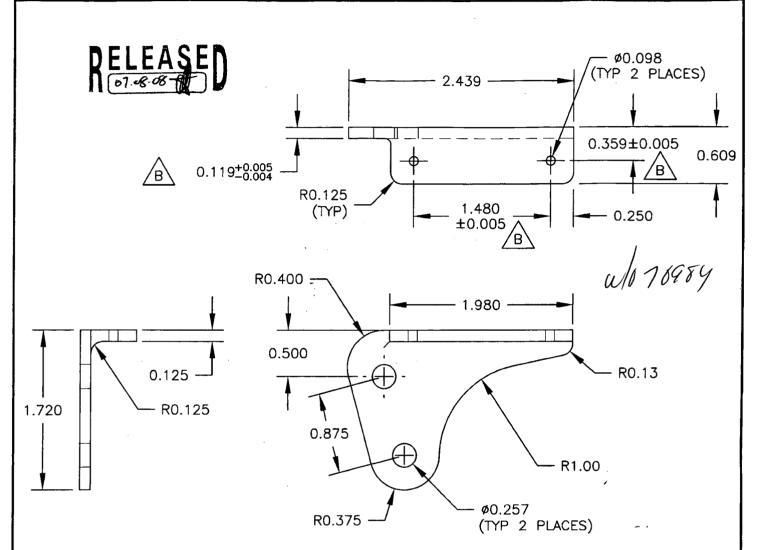
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1 A		D3278	SHEET 2 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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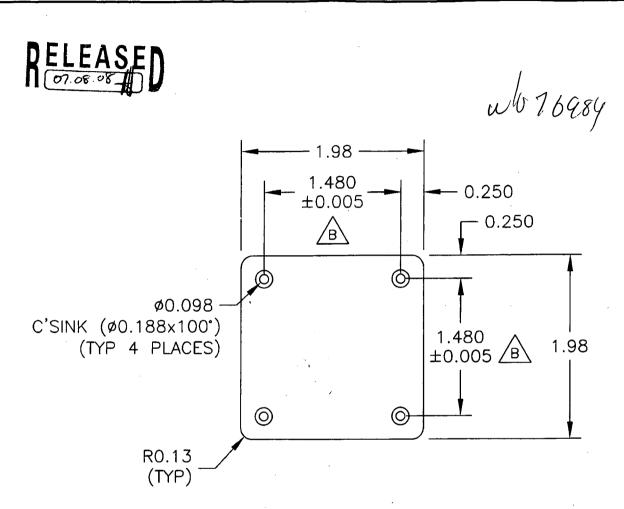
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# A	- - - - - - - -	D3278	SHEET 3 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1



D3278-3 SPACER

1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR

DELRIN II 150E OR ACETRON GP ACETAL (REF. DART SPEC. M-DELRIN-S.125)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approvai Chief Eng / Prod Mgr	Approval QC Inspector			
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